

Date: Wednesday, 28/01/2009 4:59:44 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206 A/B HIGH GEAR WEB		
Job Number	: 45319		Part Number	: D26543		
Estimate Number	: 10455		Drawing Number	: D2654 REV E1		
P.O. Number	:		Project Number	: N/A		
This Issue	: 28/01/2009	S.O. No.	Type	Drawing Revision	Material	Qty: 2 Um: Each
Prsht Rev.	: NC		SKIDTUBES	E1	:	
First Issue	: / /					
Previous Run	: 44280					
Written By	:		Due Date	: 05/02/2009		
Checked & Approved By	: <u>SL 9-2-1</u>					
Comment	: Est Rev:D 99.02.04 Fixed typo, Changed procedure DM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :			
1.0	D26005108	Extrusion 'I Beam' thin			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2600-5 Web <u>38589</u> <u>SL 9-2-1</u>					
2.0	SKIDTUBES 1	SKIDTUBES RESOURCE 1			
Comment: LANDING GEAR RESOURCE 1 1-Cut D2600-5 to length as per Dwg D2654 2-Drill pilot holes in web using drill jig DT 8018-3 as per Dwg D2654 3-Using the uni-bit, open holes to finish size as per Dwg D2654 4-Deburr holes and ends					
3.0	QC5	INSPECT WORK TO CURRENT STEP			
Comment: INSPECT WORK TO CURRENT STEP					
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1			
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 206 A/B HIGH GEAR WEB

Job Number: 45319

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Job Number:



Seq. #: Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

2 4 9-2-2

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: L6

SL 9-2-1

7.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/03 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-02-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

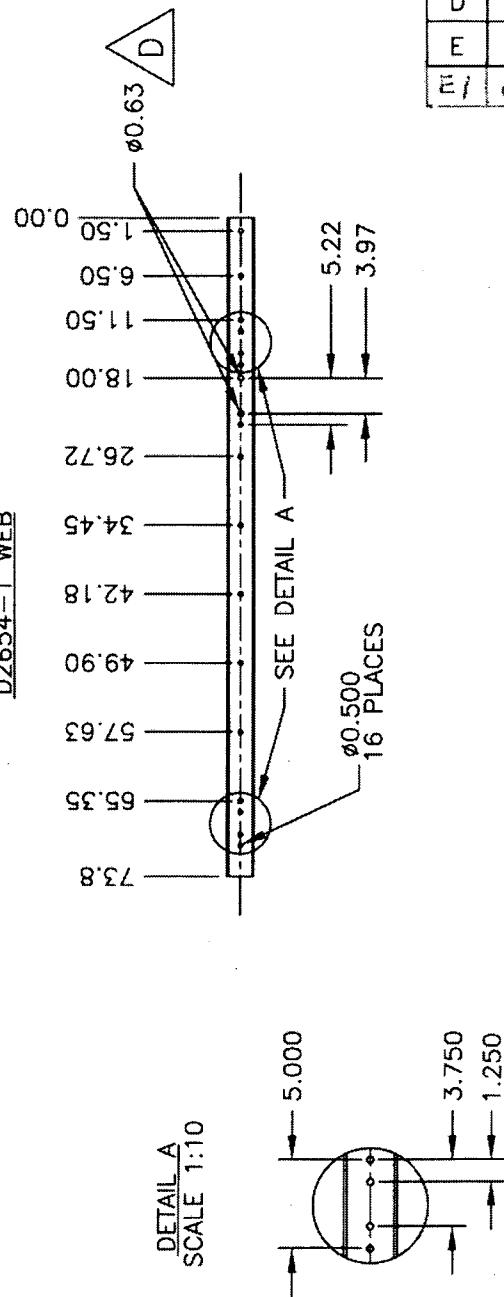


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03/03

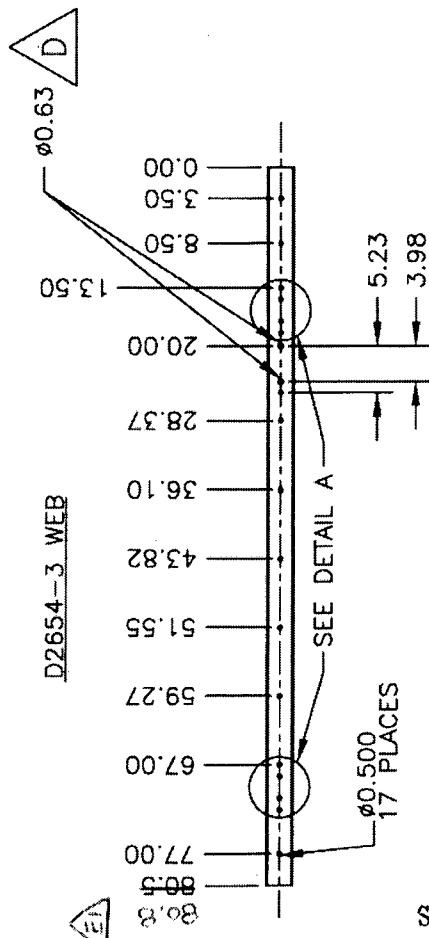
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO:	REV. E
		D2654	SHEET 1 OF 2
DATE		TITLE	SCALE
04.05.26		WEB	1:20

RELEASED
04.06.22

D2654-1 WEB



D2654-3 WEB



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WITH NOTICE
NO. WJ319

MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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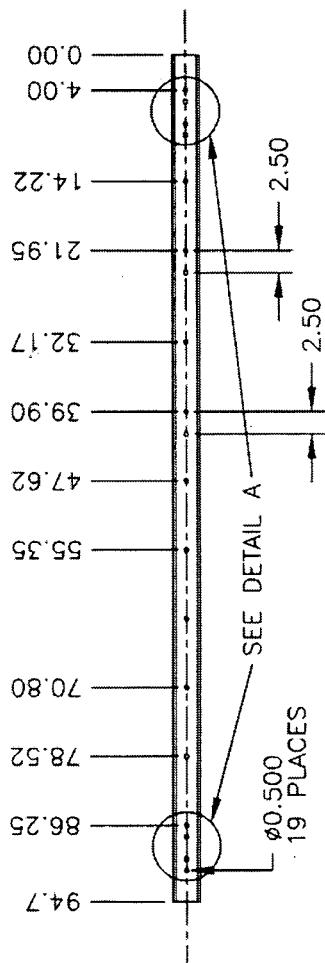
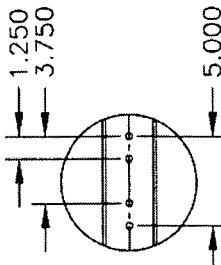
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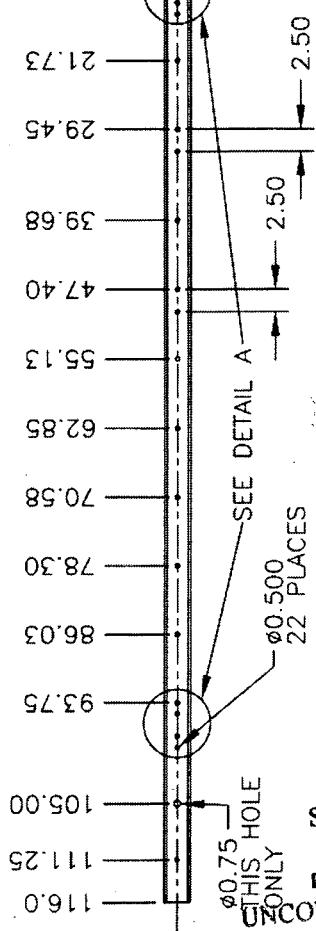
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CHECKED	APPROVED	DRAWING NO. D2654 REV. E SHEET 2 OF 2
DATE		TITLE WEB SCALE 1:20

RELEASED
04.06.22

D2654-5 WEB

DETAIL A
SCALE 1:10

D2654-7 WEB

DATE
04.05.26TITLE
WEBSCALE
1:20

MAKE FROM D2600-7-125 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
THIS HOLE
ONLY
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